



Dart Hawkesbury
1270 Aberdeen St
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D350-591-311
Job Sheet 167183



Part No: D350-591-311

Job Qty: 6 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 10/26/17

Job Tracking No:

Due Date: 10/27/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Ship Via:

FG083

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		10/26/17	0.00	0.00	Start Up Large Fab2		D.M.L
110	Large Fab	6 pcs		10/26/17	0.00	5.95	Large Fab 2		S.L 11/1/17
120	QC	6 pcs		10/26/17	0.00	0.00	QC9		CPL 11/2/17
130	QC	6 pcs		10/26/17	0.00	0.00	QC5		CPL 2017/11/02
140	HandFinish	6 pcs		10/26/17	0.00	1.10	HandFinish1		CPL
150	QC	6 pcs		10/26/17	0.00	0.00	QC7		SL 11/16/17
180	Large Fab	6 pcs		10/26/17	0.00	5.95	Large Fab 2		38 DAS 38
190	QC	6 pcs		10/26/17	0.00	0.00	QC10		2017-11-06 38
200	QC	6 pcs		10/26/17	0.00	0.00	QC5		BK
210	HandFinish	6 pcs		10/26/17	0.00	1.10	HandFinish1		12/10/17 (x6)
220	Powdercoat	6 pcs		10/26/17	0.00	1.74	Powdercoat1		38
230	HandFinish	6 pcs		10/27/17	0.00	1.10	HandFinish3		38
240	QC	6 pcs		10/27/17	0.00	0.00	QC3		38
250	Packaging	6 pcs		10/27/17	0.00	0.00	Packaging1		38
260	QC	6 pcs		10/27/17	0.00	0.00	QC4		38
265	DC	6 pcs		10/27/17	0.00	0.00	DC		38
270	Packaging	6 pcs		10/27/17	0.00	0.00	Packaging3		38
280	QC21-FG	6 Ea		10/27/17	0.00	0.00	QC21		17/11/20

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 127078 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 10:40 OVEN TEMPERATURE: 300 FINISH TIME: 11:10

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3067-1 166077	6	69	0	0
	D3219-1 166284-2	12	133	0	0
	D3272-1 162484	6	13	0	0
180-Large Fab	D3065-041	6	48	0	0

F 165610-5 < 166514-1 Plex 10/26/17 8:05 AM dart.Michaud-Febrille.Victoria

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

250-Packaging	D3066-1	165744 ✓	12	66	0	0
	D3067-1	165725 ✓	6	69	0	0
	MS20600-AD4W4	✓	96	626	0	0
	AN3-35A	5007441 ✓	12	72	0	0
	AN4-13A	5002310x9	48	506	0	0
	AN5-36A	FM13763.63x2 ✓	12	102	0	0
	D2230-3	5007433 ✓	24	132	0	0
	D2618	5000452x7 ✓	12	37	0	0
	D2856-400-720	5007442 ✓	12	125	0	0
	D3235-1	5007462x8 ✓	12	13	0	0
	D3278-041	5007429x8 ✓	6	27	0	0
	MS21042L3	500742 ✓	12	881	0	0
	MS21042L4	5007422 ✓	48	967	0	0
	MS21042L5	500742 ✓	12	488	0	0
	NAS1149D0363J	5007420 ✓	24	955	0	0
	NAS1149D0463J	5007419 ✓	96	1,985	0	0
	NAS1149D0563J	5007417 ✓	24	1,766	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION F: _____ U: _____ Suspected Unap		DEPARTMENT/PROCESS S004350 Heil - Access - Step LH - High Gear, Long Step, Aerazur Float Compatible PART NO: D350 - 591 - 311 Revision: Large Fab Operation: 6 Quantity: 6 Change No:		Water Jet ☐ Prod. Eng. Coord. ☐ Prep/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐ MRB (QSI042) Approval ☐ Completed By ☐ Lead hand / Supervisor Approval Verification ☐ QC / QA Coordinator Approval ☐	
Date: _____		Step #: _____		Mfg Date: 10/31/17 Job No: 167183		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Description Work Order Deviation							
Root Cause							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Process/Program	☐
Design	☐	Operator	☐	Bending	☐	Stock Pulled	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Conce	☐	Sequence	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Finished	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple	☐	Function	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Misaligned/off center	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐		
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐		
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐		
Substation	☐	Process Improvement	☐	Marks/Chatter	☐		
Past Expiry Date	☐	Manufacturing Process	☐		☐		
Misidentified	☐	Past Due	☐	OTHER :	☐		

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hell-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hell-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hell-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hell-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hell-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hell-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.